

Date: Monday, 6/19/2006 11:25:58 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STOP
 Job Number : 27616
 Estimate Number : 10514
 P.O. Number : *NIA*
 This Issue : 6/19/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : MACHINED PARTS
 Previous Run : 27304
 Part Number : D28051
 Drawing Number : D2805 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : *NIA*
 Due Date : 7/5/2006
 Qty: *21* / 12 Um: Each
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06.06.19*
 Comment : Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X01500 6061-T6 Bar 1.5" x 1.5"



Comment: Qty.: 0.2756 f(s)/Unit Total : 3.3075 f(s) *
 6061-T6 Bar 1.5" x 1.5"
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"
 (M6061T6B1500X01500) Batch: *M16954*

JK 06/06/24

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut Bar: 3.150" Long +0.010/-0.030"

JK 06/06/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA104 and Dwg D2805
 2- Tumble and Deburr
 Identify as D2805-1

JK 06/06/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JK 06/06/24

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JK 06/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/24	3	- 2 parts scrapped - drills broke in hole	AB 06/06/24	- scrap + replace	J.L 06/06/24	06/06/26	06/06/26	06/06/26

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:25:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 27616

Part Number: D28051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H.M 06-06-28

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

M

06 06 29

(21)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 386

H.M 06-06-30

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/05

(21)

Job Completion



W. De. 07/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

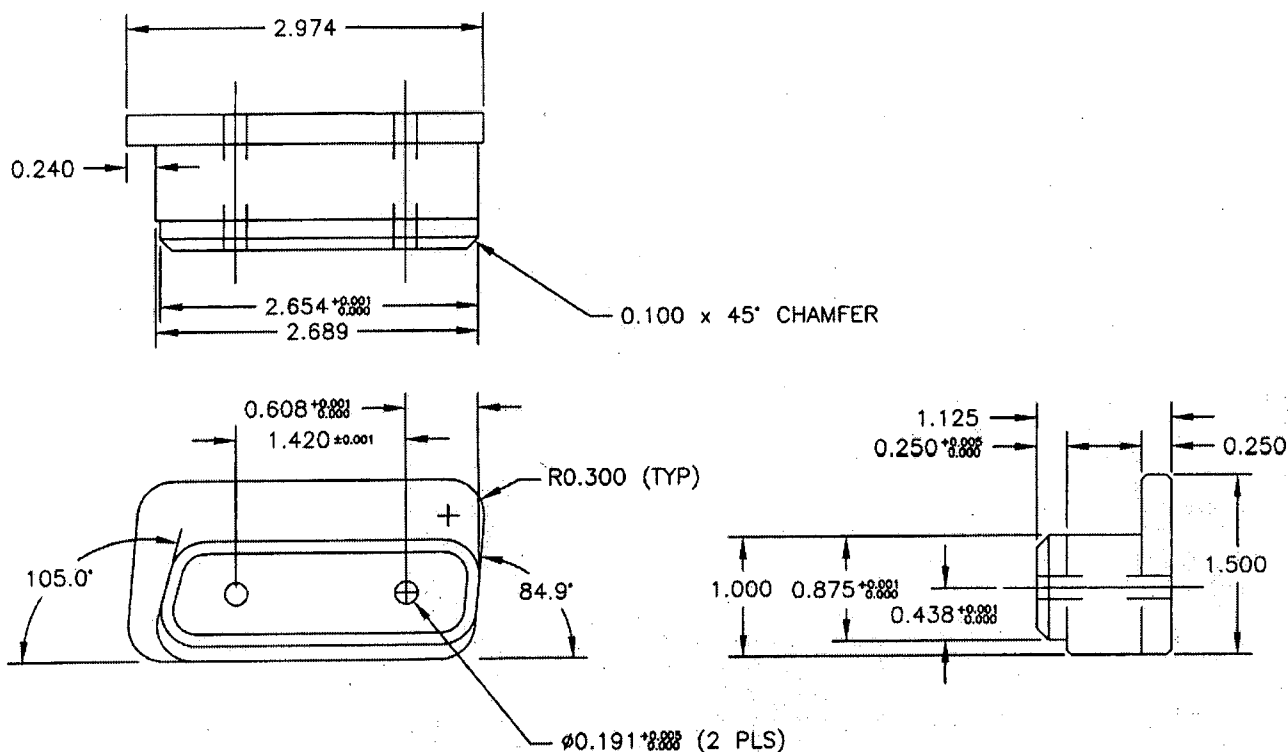
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #

D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27616

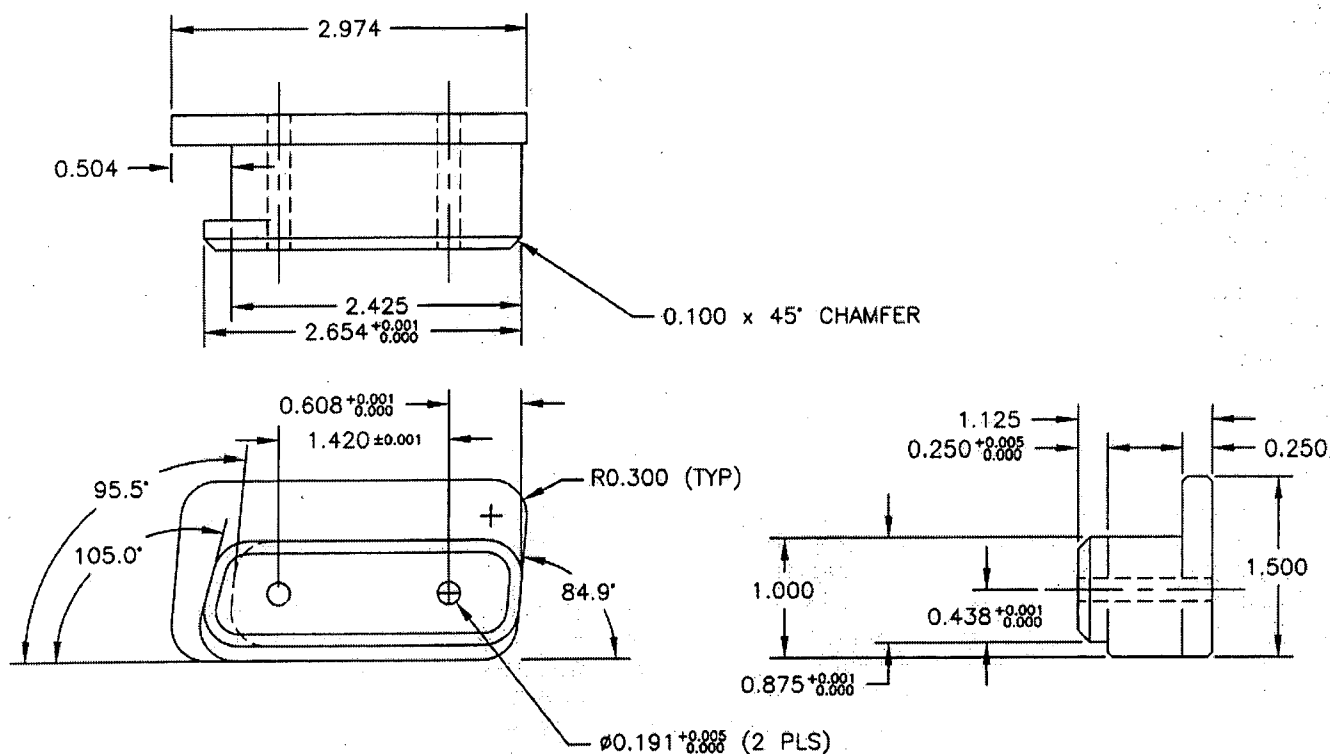
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DESIGN #	DRAWN BY IP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
NOTED TO AMENDMENT

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED
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WORK ORDER
NO. 27616

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